

Work Order ID 82549

April-03-12 8:30:47 AM

82549

Page 1

Item ID: D2756

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Inner Doubler

Stop ***NS2***

Start Date: 03/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/03

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <u>Draw Nbr</u> | <u>Revision Nbr</u> | | | | | | | | |
| <u>02756</u> | <u>Rev A</u> | | | | | | | | |
| 100 | SHEAR | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg | | | | | | | | |
| <u>2034 .040</u> | Dwg Rev: <u>1A</u> | | | | | | | | |
| | Prog Rev: <u>1A</u> | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *110* | HAAS CNC VERTICAL MACHINING #1 | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

8 0 Jim 12-6-14

8 0 Jim 12-6-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Item ID: D2756

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Inner Doubler

Stop

NS2

Start Date: 03/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID 82549

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Item ID: D2756

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Inner Doubler

Stop ***NS2***

Start Date: 03/04/2012 Start Qty: 8.00

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Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Identify as per dwg & Stock Location: <u>17</u> | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | 82 | | 12/6/18 | |
| Packaging | | | | | | | | | |
| 160 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12/6/18
Kearis

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

April-03-12 8:30:52 AM

Page 1

Work Order ID: 82549

82549

Parent Item: D2756

D2756

Parent Item Name: Inner Doubler

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP B98.11.25New order of procedure DM IPP REV;C
11.12.21 MADE ON WATERJET DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M2024T3S.040

Purchased

No

100

sf

263.5912

0.1458

1.227789

**

M2024T3S 040

2024-T3 .040 sheet

JW 12-6-14

Location

Loc Qty

Loc Code

MAT022

263.5911626

117684

21.318421

120196

59.41

120605

86.8627416

121197

96

120605

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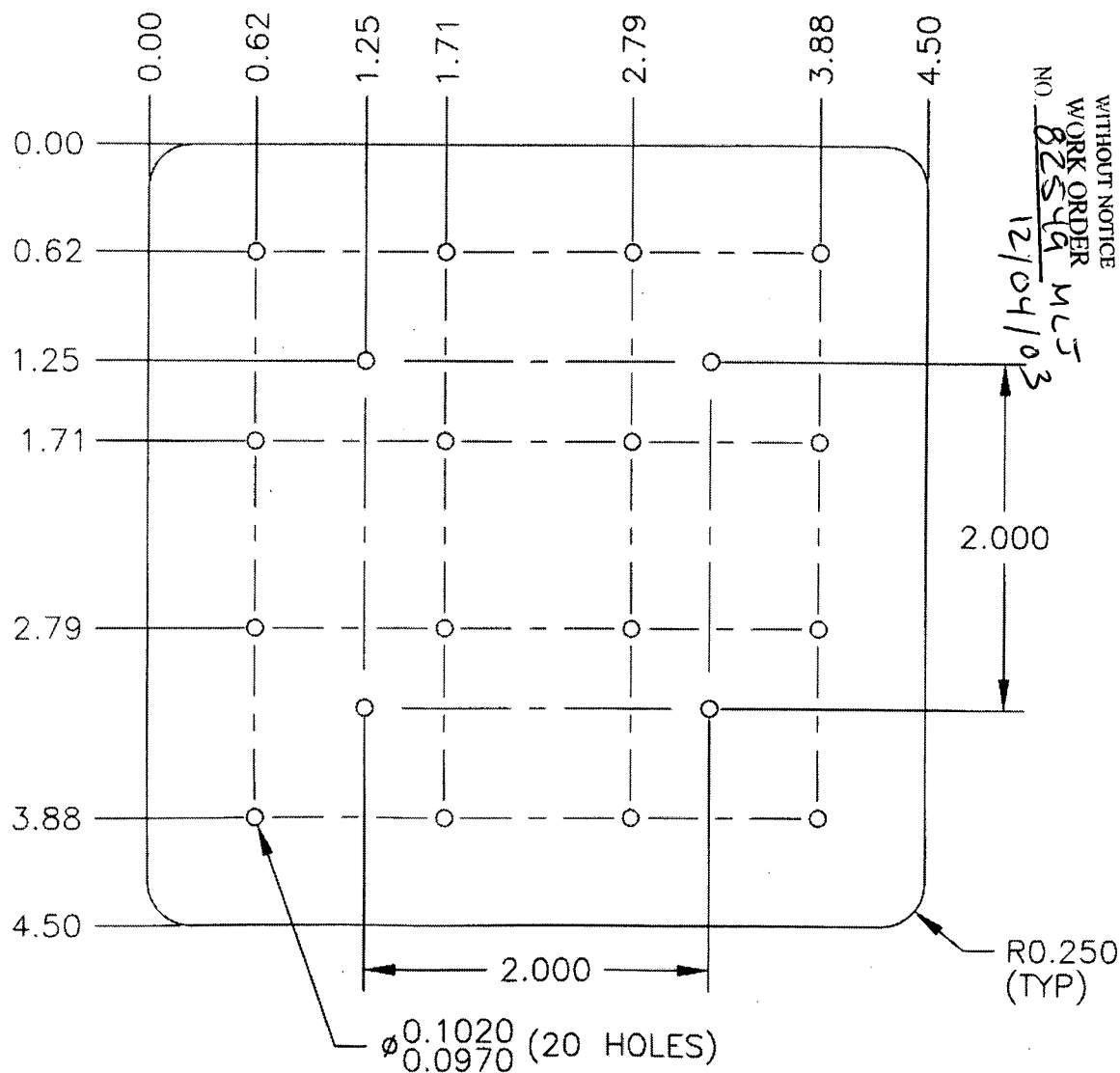
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



RELEASED
99/04/20 KE



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| W/O: | | WORK ORDER CHANGES | | | | | |
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